

Date: Thursday, 4/5/2007 11:58:55 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ANGLE  
 Job Number : 31690  
 Estimate Number : 10196  
 P.O. Number : N/A Part Number : D21751-2  
 This Issue : 4/5/2007 S.O. No. : N/A Drawing Number : D2175 REV E  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : E  
 Previous Run : 30871 Material : N/A  
 Due Date : 4/30/2007 Qty: 40 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est E 04-06-09 Reformat KJ/RF  
 Est Rev:F 06-04-28 Manufactured on Water Jet JLM  
 Est Rev:G As per Rev E 06-11-22 JLM

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M2024T3S063

2024-T3 .063 sheet



Comment: Qty.: 0.4958 sf(s)/Unit Total : 19.8324 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.063" thick  
 (M2024T3S.063)

Batch: M103321

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2175

Dwg Rev: E

Prog Rev: E

2-Deburr if necessary

SAD 07/05/17

40

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/17

40

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SAD 07/05/17

40

5.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr Stack

SAD 07/05/23

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 31690

Part Number: D21751

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2175

SB 07/05/23

PTO

29

38

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20405-24

counted (29)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL/BL

07/05/24 (29)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

EP 07/05/24 (29)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

EP 07/05/24 (29)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

EP 07/05/25 (29)


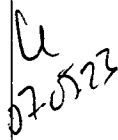
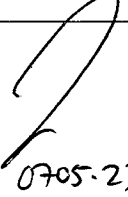
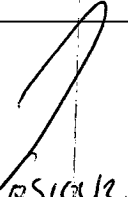

Job Completion



U 07/05/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/25  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0705-23	6.0	Parts were bent as -2. operator error, did not focus on Dwg: Qty.	 QSI0412	This w/o is now a -2, Qty 29, from w/o 31691.	 0705-23	 0705-23	 QSI0412	 0705-23

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 31690
<b>Description:</b> Angle		<b>Part Number:</b> D2175-1/-2
<b>Inspection Dwg:</b> D2175 <b>Rev:</b> E		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article    ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.650	+/-0.010	12.650	✓		M-T	
R0.35	+/-0.030	R-0.35	✓		R-b	
2.915	+/-0.010	2.922	✓		Vern	
50°	+/-0.5°	50°	✓		Bevel Protractor	
0.300	+/-0.010	0.303	✓		Vern	
1.050 Pitch	+/-0.010	1.053	✓		Vern	
10.500	+/-0.010	10.500	✓		M-T	
11.550	+/-0.010	11.551	✓		M-T	
0.550	+/-0.010	0.555	✓		Vern	
0.900	+/-0.010	0.903	✓		Vern	
0.063 thick	+/-0.010	0.062	✓		Vern	
Grain Direction	N/A		✓			
Ø0.128	+0.005/-0.001	Ø0.128	✓		Vern	
Ø0.172	+0.005/-0.001	Ø0.173	✓		Vern	

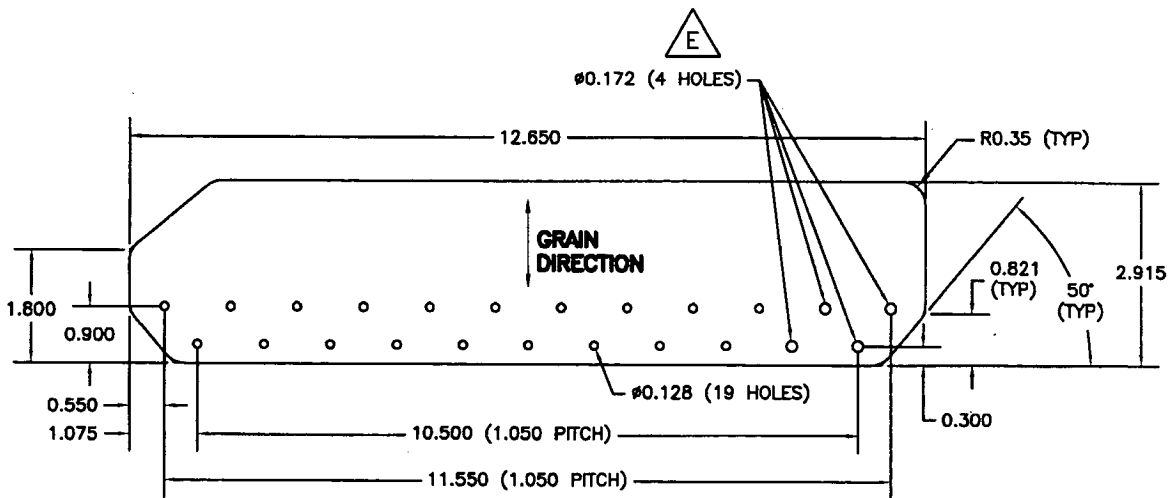
<b>Measured by:</b> SAD	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/05/12	<b>Date:</b> 07/05/12	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.03.23	Dimensions revised per Dwg rev. E	KJ/JLM [Signature]	[Signature]

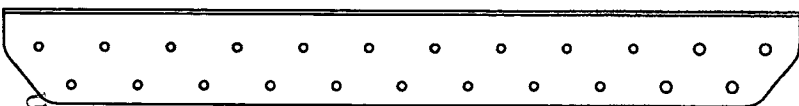
**DART**

RELEASED  
06.10.13

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		
RF	CE	DRAWING NO.	REV. E	
CHECKED PH	APPROVED [Signature]	D2175	SHEET 1 OF 1	
DATE 06.09.25	TITLE ANGLE	SCALE 1:3		
A	95.10.25	NEW ISSUE		
B	96.01.18	CHANGED DIMENSION		
C	00.09.11	UPDATE FINISH SPEC		
D	04.06.03	RE-DESIGN		
E	06.09.25	INC HOLE DIA TO Ø0.172, 4 HOLES		



**D2175-1F FLAT PATTERN**



**D2175-1 BEND DETAIL SHOWN  
(D2175-2 BENT OPPOSITE)**

**NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31690